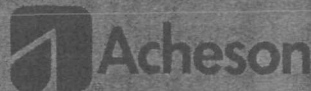


Product Data Sheet

PORSE
11.3.1251/1
NO DATE



Acheson Colloids Company
Port Huron, Michigan 48060

DELTAForge 1105

Water Based,
Synthetic Die Lubricant

Description:

Deltaforge 1105 is a nongraphited, water based die lubricant formulated to provide effective lubrication and release when hot forging on presses and hammers. It is capable of wetting dies at temperatures as high as 800°F (427°C), and excels where metal movement is severe.

Deltaforge 1105 is formulated for application by spray, but can also be successfully swab applied. Regardless of the application method chosen, it allows economical dilution ratios. Deltaforge 1105 is odorless, nontoxic, smokeless and provides for a cleaner plant environment. Additional advantages of the product include:

- no settling
- reduced buildup on tooling and presses
- not damaged by freezing
- lessens plugging of spray nozzles

Typical Applications:

Hot Forging of Steel

Physical Properties:

Lubricant	: soluble synthetic
Carrier/diluent	: water
Consistency	: pale green liquid
Density	: 9.1 lb/gal
Flash point	: none
Freezing point	: 28°F (-2°C)
Shelf life	: one year under original seal

Method of Use:

Dilution

Deltaforge 1105 is normally diluted by adding water to the product (not vice versa) prior to application on forging dies. A typical dilution ratio of 1:5 (product:water) is suggested for initial evaluation. Actual dilution ratios vary depending on part complexity and application technique.

Application

Spray application is recommended, however, product can be successfully swab applied.

Note: Consult your local Acheson representative for additional product and Dag® Lubrimate application equipment information.

Precautions:

If frozen, allow product to completely thaw before proceeding with the described method of use.

Container Sizes:

5 gallon (18.9 liter)
55 gallon (208 liter)

USEPA SF



1265457

Information presented in this product data sheet is considered reliable, but conditions and methods of use, which are beyond our control, may modify results. Before adopting our products for commercial use, the user should confirm their suitability. In no case should recommendations or suggestions for the use of our products be understood to sanction violation of any patent.